

Date: Tuesday, 2/26/2008 7:59:51 AM  
User: Kim Johnston

Process Sheet

*SPUT*

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HOUSING WELDMENT
Job Number : 37604	
Estimate Number : 11874	
P.O. Number :	Part Number : D2207041
This Issue : 2/26/2008 S.O. No. :	Drawing Number : D2207 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 35075	Material :
Written By :	Due Date : 3/22/2008 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. C 01-10-18 Added Step 10 and 11 SM	
Est D 07-10-11 REV C dwg DD verified by EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2208 End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

End Cap

Pick:

Qty	Part Number	Description	Batch
2	D2208	End cap	<i>B37743</i> ✓

*[Signature]* 08/03/31

2.0 D2207 Housing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Housing

Pick:

Qty	Part Number	Description	Batch
1	D2207-1	Housing	<i>B36094 → 8x</i> ✓ <i>B34326 → 2x</i> ✓

*[Signature]* 08/03/31

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Chamfer D2208 and D2207-1 before welding

2-Weld as per dwg D2207

3-Grind welds flush as per Dwg D2207

*SAN 08/04/01* *[Signature]* 08/04/01 **(5x)**

4.0 ~~QC 10/5~~ VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*[Signature]* 08/04/02 **(X)**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Job Number: 37604

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL FABRICATION RESOURCE 1

Drill holes using DT8557 as per Dwg D2207

FF 08-04-02

(5)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/02 (X5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/04/02

(5X)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

Bl 08-04-03

(5)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/04/04 (5)

10.0

ALS71032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Insert

Qty Part Number

Description Batch

4 ALS7-1032-130

Insert

M105854

\*

SEE QSI-017

YJ

08-04-04

(X5)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install AK57-1032-130 as per Dwg D2207

YJ

08-04-04

(X5)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/04 (X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Job Number: 37604

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 477

8/4/4 54 (3x)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod-Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

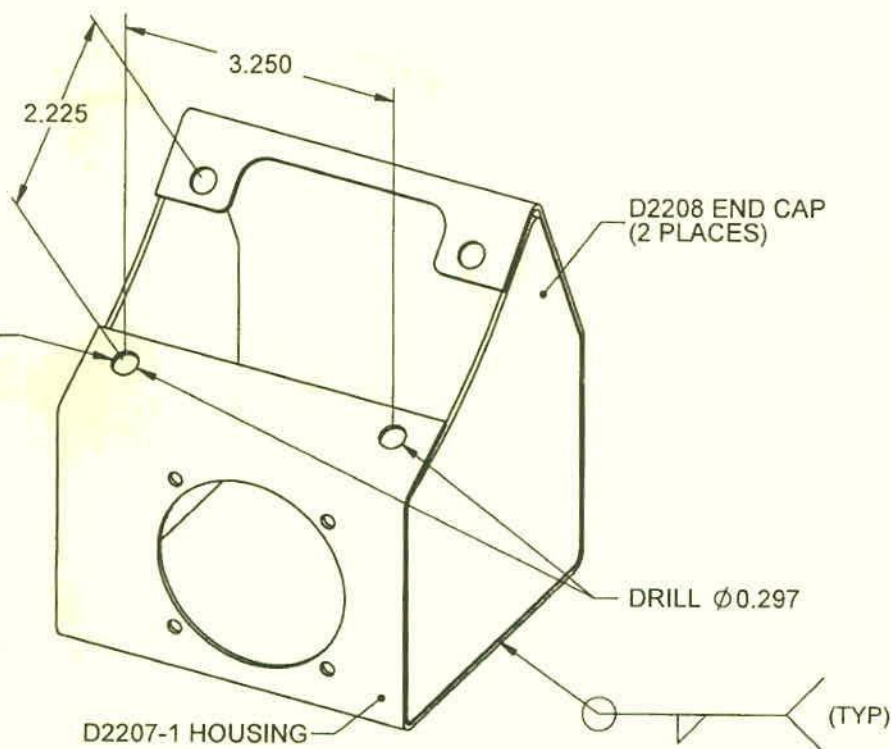
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



AFTER FINISH, INSTALL  
AKS7-1032-130 OR  
ALS7-1032-130 OR  
AKS4-1032-130 OR  
ALS4-1032-130  
(4 PLACES)



RELEASED

07.08.29

### D2207-041 HOUSING ASSEMBLY

NO. 37604  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

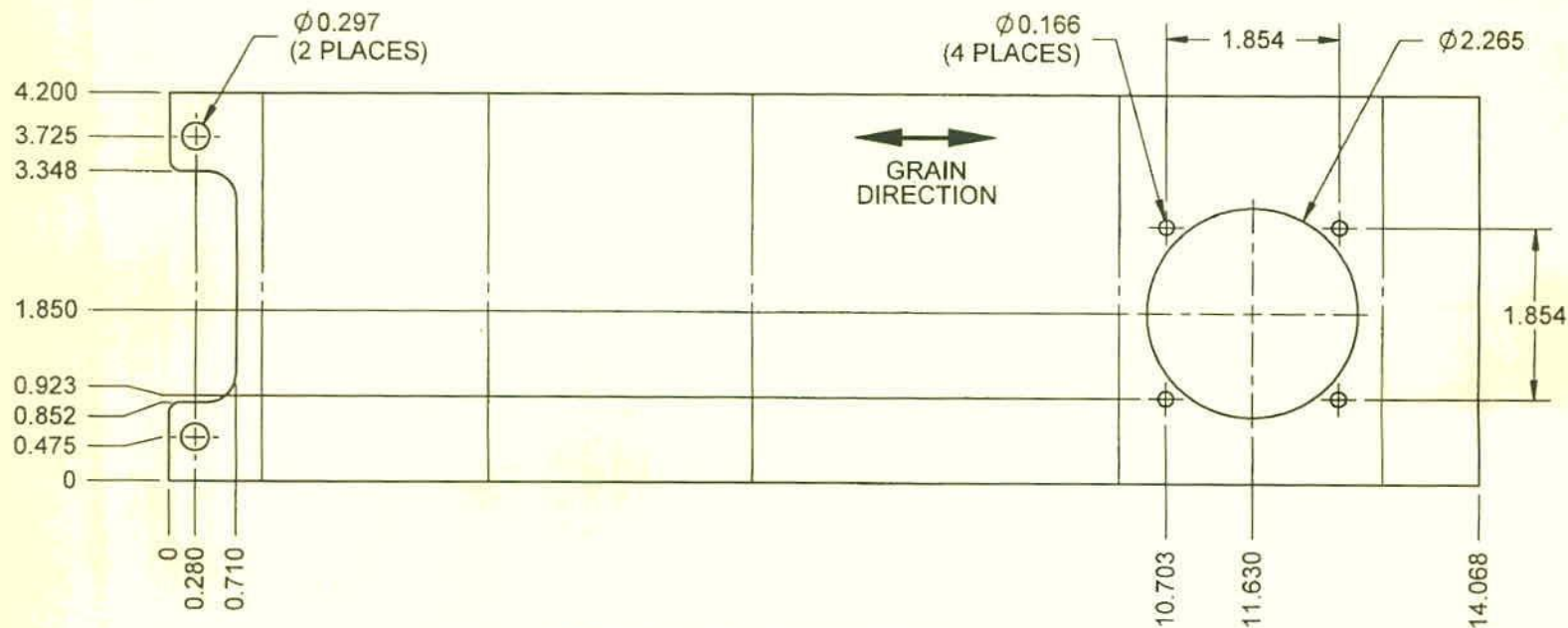
C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>CE</i>	D2207	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HOUSING	1:2
DATE	07.06.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED



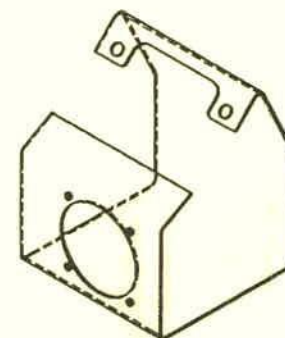




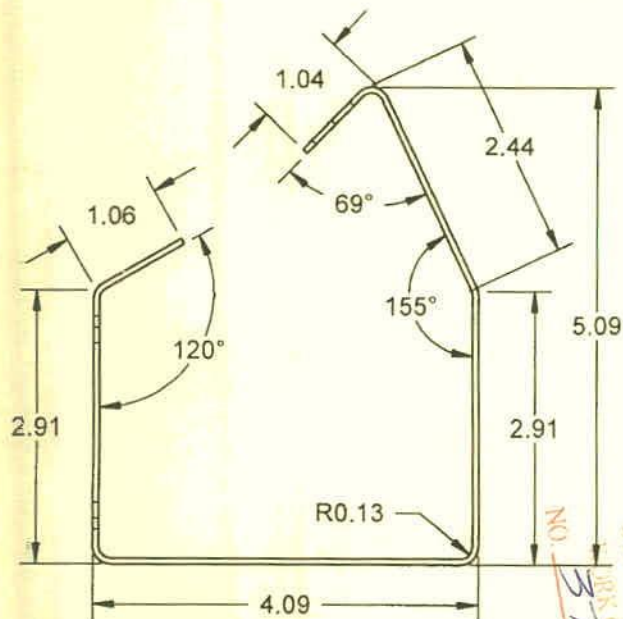
### D2207-1F FLAT PATTERN

#### NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.063) OR  
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



**ISOMETRIC VIEW**  
(SCALE 1 : 4)



**D2207-1 BENDING DETAIL**

**RELEASED**

07.08.29

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RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

NO. 37604

DESIGN	<del>PH</del>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<del>PH</del>		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	<del>PH</del>	D2207	SHEET 2 OF 2
APPROVED	<del>PH</del>	TITLE	SCALE
DE APPR.	<del>PH</del>	HOUSING	1:2
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